

## CLAIMS:

1. A method for applying an end panel 36 to a closure ring 30 for a container 60, wherein said closure ring includes an inwardly directed annular flange portion 34 having a central opening for filling and emptying an associated container, said flange portion 34 being initially disposed in a plane in a planar configuration, said method including the step of securing a peripheral portion 38 of an end panel 36 for a container to said planar disposed flange portion 34, said method being characterized by the step of displacing said flange portion, with said end panel secured thereto, from said plane to an angle thereto for forming an angle A with said plane prior to securing said ring member and end panel to a container.

2. A method as defined in claim 1 including the step of forming said angle within a range between 5 and 45 degrees.

3. A method as defined in claim 2 including the step of forming said angle to be approximately 25 degrees.

4. A method as defined in claim 1 wherein the step of securing said end panel to said flange portion includes the step of heat sealing said flange portion to said peripheral portion of said end panel.

5. A method as defined in claim 4 including the step of applying a layer of adhesive material to said peripheral portion of said end panel for sealing said peripheral portion to said flange portion.

6. A method as defined in claim 5 wherein said end panel is formed of foil.

7. A method as defined in claim 5 wherein said end panel is formed of thermoplastic material.